




STATEMENT

I, Keiko Tanaka Kubovcik, hereby state that I am competent in both the Japanese and English languages and that the attached English language document is an accurate translation of Japanese Patent Application No. 2002-226840, filed August 5, 2002.

Date: February 15, 2007

Signature: 



JAPANESE PATENT OFFICE

This is to certify that the annexed is a true copy of the following application as filed with this Office.

Date of Application: August 5, 2002

Application Number: JP2002-226840

Applicant(s): Sanyo Electric Co., Ltd.

July 9, 2003
Commissioner, Japanese Patent Office
Shinichiro Ohta



[Document Name] Petition for Patent
[Reference Number] LCA1020040
[Filing Date] August 5, 2002
[To] Commissioner, Japanese Patent Office
[International Patent Classification] H01M 10/40

[Inventor]
[Address or Residence] c/o SANYO Electric Co., Ltd.
5-5, Keihanhondori 2-chome
Moriguchi-shi, Osaka 570-8677
Japan

[Name] Naoya NAKANISHI

[Inventor]
[Address or Residence] c/o SANYO Electric Co., Ltd.
5-5, Keihanhondori 2-chome
Moriguchi-shi, Osaka 570-8677
Japan

[Name] Kouichi SATO

[Inventor]
[Address or Residence] c/o SANYO Electric Co., Ltd.
5-5, Keihanhondori 2-chome
Moriguchi-shi, Osaka 570-8677
Japan

[Name] Atsuhiko FUNAHASHI

[Inventor]
[Address or Residence] c/o SANYO Electric Co., Ltd.
5-5, Keihanhondori 2-chome
Moriguchi-shi, Osaka 570-8677
Japan

[Name] Toshiyuki NOHMA

[Inventor]
[Address or Residence] c/o SANYO Electric Co., Ltd.
5-5, Keihanhondori 2-chome
Moriguchi-shi, Osaka 570-8677
Japan

[Name] Yasuhiro YAMAUCHI

[Inventor]
[Address or Residence] c/o SANYO Electric Co., Ltd.
5-5, Keihanhondori 2-chome
Moriguchi-shi, Osaka 570-8677

Japan

[Name] Noriyuki MIYAZAKI

[Applicant]

[Identification Number] 000001889

[Name] SANYO Electric Co., Ltd.

[Agent]

[Identification Number] 100100114

[Patent Attorney]

[Name] Nobuyasu Nishioka

[Telephone No.] 06-6940-1766

[Official Fee]

[Number of Account] 037811

[Amount] 21,000

[List of Attached Documents]

[Title of Attached Document] Specification 1

[Title of Attached Document] Drawings 1

[Title of Attached Document] Abstract 1

[Proof] Demanded

SPECIFICATION

[TITLE OF THE INVENTION] **BATTERY**

[CLAIMS]

1. A battery comprising an electrode unit as an electricity generating element housed in a battery can, and a pair of negative and positive electrode terminals for taking the electricity out of the battery, wherein a terminal assembly of one of said negative and positive electrode terminals is secured to a lid of the battery, a current collector plate is connected to an edge of an electrode of the electrode unit to electrically connect the electrode unit to the terminal assembly, and one or more than one connecting piece which is protrusively formed on a surface of the current collector plate is welded to a base portion of the terminal assembly.

2. The battery according to claim 1, wherein the base portion of the terminal assembly comprises a flange portion (70) and said flange portion (70) is connected to an inner circumferential wall or outer circumferential wall of said one or more than one connecting piece (63) and is welded to said one or more than one connecting piece (63) by laser beam welding.

3. The battery according to claim 2, wherein an outer circumferential wall of said one or more than one connecting piece

(63) and the inner circumferential wall of the flange portion (70) are connected to form a connection, and a laser beam is irradiated onto said connection from outside the flange portion (70) to weld said current collector plate to said terminal assembly.

[DETAILED EXPLANATION OF THE INVENTION]

[0001]

[FIELD OF THE INVENTION]

The present invention relates to a battery such as a lithium ion secondary battery in which an electrode unit which is an electricity generating element is housed in a battery can, and electricity generated by the electrode can be taken out from the can.

[BACKGROUND OF THE INVENTION]

[0002]

A lithium ion secondary battery having a high energy density has recently received attention as a power source for portable electronic equipment, electric vehicles, and the like. A cylindrical lithium ion secondary battery, as shown in Fig. 13, includes a spirally wound, or rolled-up, electrode unit (2) housed in a positive electrode can (1), and a sealing plate (11) fixed on an opening of the positive electrode can (1). An insulator (12) is placed between the positive electrode can (1) and the sealing

plate (11). A negative electrode terminal (13) having a built-in gas vent valve (14) is connected to the sealing plate (11).

[0003]

The spirally wound electrode (2) comprises a negative electrode (21), separator (22) and positive electrode (23), each in the form of a strip. The negative electrode (21) and the positive electrode (23) are shifted widthwise of the separator when they are placed on the separator (22) to be spirally wound. An edge of the negative electrode (21) projects outward beyond an edge of separator (22) at one axial end of the spiral electrode (2), and an edge of the positive electrode (23) projects outward beyond an edge of the separator (22) at the other axial end of the spirally wound electrode (2).

Current collectors (3) are placed on both ends of the spirally wound electrode (2). The current collector (3) on the negative electrode side is welded through a tab (31) onto a back of the sealing plate (11), and the current collector (3) on the positive electrode side is welded onto the bottom of the positive electrode can (1) through a tab (31).

This structure makes it possible to take out electricity generated by the spirally wound electrode (2) via a negative electrode terminal (13) and the positive electrode can (1).

The negative electrode terminal (13) is made of nickel, copper

or stainless steel that is stable at a negative electrode potential. The positive electrode can (1) is made of aluminum or aluminum alloy that is stable at a positive electrode potential.

[0004]

The above explained batteries are connected in series to obtain a desired output voltage as shown in Fig. 14.

[0005]

[PROBLEMS TO BE SOLVED]

However, a length of the current path of the spirally wound electrode unit (2) and the sealing plate (11) is long because a conventional lithium ion secondary battery as shown in Fig. 13 uses a tab (31) as a means for connecting the spirally wound electrode unit (2) and the sealing plate (11). The long current path increases internal resistance and decreases battery volume efficiency due to increase of deadspace caused by placement of the tab (31).

An object of the present invention is to provide a battery in which the internal resistance is reduced and battery volume efficiency is increased.

[MEANS FOR SOLVING THE PROBLEMS]

[0006]

A battery of the present invention includes an electrode unit housed in a battery can and which generates electricity which can be taken out of the battery via a pair of negative and positive electrode terminals, wherein a terminal assembly is installed in the battery, a current collector plate is connected to an edge of an electrode of the electrode unit for connecting the electrode unit to the terminal assembly, and one or more than one connecting piece which is protrusively formed on a surface of the current collector plate is welded and secured to a base portion of the terminal assembly.

[0007]

In the present invention, one or more connecting pieces protrusively formed on a current collector plate is directly welded to the base portion of the terminal assembly to electrically connect the electrode unit and the terminal assembly so that the length of current path from the electrode unit to the terminal assembly is shortened as compared to a conventional tab connection and electrical resistance in the path becomes extremely low.

Direct welding of the current collector plate by way of the one or more connecting pieces to the base portion of the terminal assembly almost eliminates deadspace in the battery can.

[0008]

A flange portion (70) to be attached to an inner or outer circumferential wall of a connecting piece or pieces (63) is formed on and projects from the base portion of the terminal assembly and the flange portion (70) is welded to the connecting piece or pieces (63) by laser beam welding.

According to an embodiment of the present invention, the flange portion (70) and connecting piece or pieces (63) are connected at the same height from the electrode unit, and an increase of deadspace in a battery can, which is normally created in a battery can elongated in an axial direction due to the terminal assembly, is prevented.

[0009]

According to another embodiment of the present invention, an outer circumferential wall of the connecting piece or pieces (63) and an inner circumferential wall of the flange portion (70) are brought into contact, and a laser beam is irradiated from outside the flange portion (70).

This arrangement makes the welding process easy and increases productivity.

[0010]

[EFFECT OF THE INVENTION]

The present invention simultaneously achieves a reduction in

internal resistance and an increase in volume efficiency.

[0011]

[EMBODIMENTS OF THE INVENTION]

The present invention is described below in detail with reference to the drawings.

Entire Structure

As shown in Fig. 1, a battery of the present invention comprises a spirally wound electrode unit (4) housed in a cylindrical battery can (5).

The battery can (5) comprises lids (52), (53) that are secured to openings of cylinder (51) by welding. The base lid (53) forms a positive electrode terminal. A negative electrode terminal assembly (7) is formed on the upper lid (52) of the battery can (5). A negative electrode terminal (8) which comprises a part of the negative electrode terminal assembly (7) forms a negative electrode terminal portion.

Electricity generated in the electrode unit (4) can be taken out of the battery via the positive and negative electrode terminals.

A gas vent valve (50) is formed on the upper lid (52) of the battery can (5) to release pressure when pressure inside the battery increases above a certain level.

[0012]

As shown in Fig. 2, the spirally wound electrode unit (4) comprises a strip-like separator (42) sandwiched between a strip-like negative electrode (41) and a strip-like positive electrode (43) and spirally wound. The negative electrode (41) comprises a coating of a negative electrode active material (44) including carbon material coated on both sides of a strip-like current collector (45) made of a copper foil. The positive electrode (43) comprises a positive electrode active material (46), e.g., a lithium composite oxide, coated on both sides of a strip-like current collector (47). The separator (42) is impregnated with a nonaqueous electrolyte.

The negative electrode (41) includes a coated portion where the negative electrode active material (44) is coated and an uncoated portion not having the negative electrode active material (44) coated thereon. The positive electrode (43) also includes a coated portion where the positive electrode active material (46) is coated and an uncoated portion not having the positive electrode active material coated thereon.

[0013]

The negative electrode (41) and the positive electrode (43) are shifted, or displaced, in the widthwise direction relative to the separator (or axis of the electrode unit) when the negative

electrode (41) and the positive electrode (43) are placed on the separator (42) so that the uncoated portions project outside of the edges of the separator (42). Then the separator (42) sandwiched by the negative and positive electrodes is spirally wound to form the spirally wound electrode unit (4).

The uncoated portion of the current collector of the negative electrode (41) projects outwardly of the edge (48) of separator (42) at one axial end of the spirally wound electrode unit (4), and the uncoated portion of the current collector (47) of the positive electrode (43) projects outwardly of the edge (48) of separator (42) at the other axial end of the spirally wound electrode unit (4).

[0014]

Structure of Current Collector Plates

As shown in Fig. 1, current collector plates (6), (61) are attached by laser beam welding to both ends of the spirally wound electrode unit (4).

The current collector plate (6) on the negative electrode side is made of nickel, copper, nickel plated copper or nickel plated iron. As shown in Fig. 4, arc-shaped protrusions (62) (the embodiment in Fig. 4 shows four) are formed integrally on a circular disk having a center hole (60) and extend radially from the center hole. The protrusions project out the back of the

current collector plate, i.e., toward the spirally wound electrode unit (4).

The surface of the current collector plate (6) has four quarter circles each separated by two of the arc-shaped protrusions (62) (62). Four fan shape flat connecting pieces (63)~(63) are fixed to the four quarter circles by welding on a line concentrically of the center hole. Outer circumference of these four connecting pieces (63)~(63) forms a plane of a cylinder having a certain radius.

[0015]

The current collector plate (61) on the positive electrode side is made of aluminum or aluminum alloy. As shown in Fig. 9(a), a plurality of arc shape protrusions (62) (the embodiment in Fig. 9 shows four) are formed integrally on a disk having a center hole (60) and extend radially from the center hole. The protrusions project from the back of the current collector plate (61), i.e., in the direction of the spirally wound electrode unit (4).

As shown in Fig. 9(b), the surface of the current collector plate (61) has a terminal connector part (9) having a circular recessed portion (91).

It is also possible to form the terminal connector part (9) integrally on the current collector plate (61).

[0016]

In the step of welding the current collector plates (6), (61) onto both ends of the spirally wound electrode unit (4), the current collector plates (6), (61) press against the spirally wound electrode unit (4). Arc-shaped protrusions (62) of the current collector plates (6), (61) press inwardly into the edge (48) of each of the current collectors to form a connection area comprising the cylindrical contact area between the arc shape protrusions (62) and the current collector edge (48). A laser beam is irradiated to the inside of the arc shape protrusions (62) of the current collector plates (6), (61) to weld the arc-shaped protrusions (62) of the current collector plate (6) to the edge (48) of the spirally wound electrode unit (4) and to joint with a large contact area.

[0017]

Terminal Connection Structure on Negative Electrode Side

As shown in Figs. 1 and 3, the negative electrode terminal assembly (7) comprises a terminal connector (71) having a cylindrical flange portion (70) welded to a plurality of connection pieces (63) on the current collector plate (6), first and second insulators (72), (73) fitted in the center hole of the upper lid (52), a rivet means (76) having a cylindrical shape connecting the terminal connector (71) and insulators (72), (73) to the lid (52), a rubber plug (79) for closing an opening of the rivet means (76),

and a negative electrode terminal (8) which covers the rubber plug (79) and is welded on the rivet means (76).

The negative electrode terminal assembly (7) is assembled before an electrolyte is poured in the can except for the rubber plug (79) and the negative electrode terminal (8). After the electrolyte is poured in the can, the rubber plug (79) is mounted on the rivet means (76), and the negative electrode terminal (8) is welded and secured on the rivet means (76).

[0018]

The terminal connector (71) is made of nickel, nickel plated iron, copper, nickel plated copper or stainless steel.

The insulator (72) is disklike, and is adhered under pressure onto the back of the lid (52). The insulator (73) is cylindrical, and is adhered under pressure along the inside periphery of the center hole of the lid (52). The insulators (72), (73) maintain an airtight seal between the lid (52) and the negative electrode terminal assembly (7), and are made of PE, PP, nylon, a fluoroplastic resin (PFA, PTFE, and the like)); PPS or PEEK.

[0019]

A material of the rivet means (76) is chosen from nickel plated iron, nickel, copper, nickel plated copper or soft iron. As shown in Fig. 3, a projecting cylindrical part (78) is formed on a

back of a disc part (77) of rivet means. As shown in Fig. 6, the cylindrical part (78) of the rivet means (76) is inserted into center openings of the terminal connector (71) and insulators (72), (73) which are assembled on the lid (52), and bottom part (78a) of the cylindrical part (78) is caulked to secure the terminal connector (71) and insulators (72), (73) to the lid (52).

[0020]

The negative electrode terminal (8) has a two-layer clad structure consisting of a nickel layer (81) having a thickness of about 0.2 mm and an aluminum layer (82) having a thickness of about 30 μm . Cladding can be performed by a common method such as rolling under reduced pressure to bond the two layers, or with heat. A method in which heating is applied after rolling to form a diffusion layer at the interface between two layers can also be used.

The nickel layer (81) and aluminum layer (82) are uniformly bonded by the process. Therefore, there is no possibility that water or moisture penetrates into the interface between the layers (81), (82) and, thus, electric corrosion caused by contacting of different metals is prevented.

A method for bonding the layers (81), (82) is not limited to cladding. Aluminum plating onto the surface of the nickel layer (81) is also an acceptable method to form the aluminum layer (82).

[0021]

A plurality of connecting pieces (63) formed on the current collector plate (6) which is on the negative electrode of the spirally wound electrode unit (4) can be adhered to the flange portion (70) of the terminal connector (71). As shown in Fig. 6, the negative electrode terminal assembly (7) is assembled onto the lid (52), and after the current collector plate (6) having the connecting pieces (63) is fixed onto the spirally wound electrode unit (4), the inner peripheral wall of the flange portion (70) of the terminal connector (71) and the outer peripheral wall of the connecting pieces (63) of the current collector plate (6), as shown in Fig. 7, are attached together and irradiated with a laser beam outside of the flange portion (70) of the terminal connector (71) to weld the flange portion (70) of the terminal connector (71) to the connecting pieces (63) of the current collector plate (6).

[0022]

Four connecting pieces (63) ~ (63) can be formed integrally as one piece on the current collector plate (6). The connecting pieces (63) can also be arc-shaped pieces (64) instead of fan shaped pieces as shown in Fig. 5 to form a cylindrical portion to attach to the flange portion (70) of the terminal connector (71). The arc-shaped connecting pieces (64) can be formed by carving the current collector plate (6).

[0023]

Terminal Connection Structure of Positive Electrode Side

As shown in Fig. 1, the terminal connector part (9) secured on the current collector plate (61) on the positive electrode side of the spirally wound electrode unit (4) is connected to the base lid (53) of the battery can (5).

As shown in Fig. 10, the base lid (53) of the battery can (5) is formed in the center with a hole (58) having the same inner circumference as the outer circumference of the terminal connector part (9). The terminal connector part (9) is inserted into the center hole (58) of the base lid (53), then, as shown in Fig. 1, the surfaces of the lid (53) and the terminal connector part (9) are made flush and are irradiated with a laser beam from outside of the lid (53) along the circumference to laser weld (90) the terminal connector part (9) to the lid (53) as shown in Fig. 8.

[0024]

In the above explained terminal connection structure, the recessed portion (91) forms a wall inside of weld (90) on the surface of terminal connecting part (9). A groove (54) is also formed along the circumference on the surface of the lid (53) to create a wall outside of weld (90).

The weld (90) is sandwiched by the two walls to inhibit heat radiation during laser beam welding. This prevents a sudden

temperature drop at the weld (90). Defects such as cracking are thereby prevented.

[0025]

If necessary, a connecting plate (55a) of aluminum can be welded on the surface of the case lid (53) of the battery can (5) by laser beam welding to form a positive electrode terminal portion having a flat surface as shown in Fig. 11.

As shown in Fig. 11, this structure make it possible to have a definite and stable contact between a negative electrode terminal (8b) of a battery B and the connecting assistant plate (55a) which is a positive electrode terminal of battery A when they are connected in series.

[0026]

Assembly of Battery

After the spirally wound electrode unit (4) as shown in Fig. 2 is prepared, the current collector plate (6) as shown in Fig. 4 is welded to an edge of the negative electrode of the spirally wound electrode unit (4) by laser beam welding and the current collector plate (61) as shown in Fig. 9(b) is welded to an edge of the positive electrode of the spirally wound electrode unit (4) by laser beam welding.

Then, as shown in Figs. 6 and 7, the negative electrode

terminal assembly (7) is assembled except for the rubber plug (79) and negative electrode terminal (8) on the lid (52), the connecting pieces (63) on the current collector plate (6) are welded to the flange (70) of the terminal connector (71). A laser beam is irradiated outside the flange (70) for welding.

As shown in Fig. 10, the terminal connector part (9) on the current collector plate (61) is inserted into the center hole (58) of the lid (53) of the can (5) to place the surface of the terminal connector part (9) flush with the lid (53). The area of contact between the terminal connector part (9) and lid (53) is welded from outside the battery can (5).

Finally, the electrolyte is poured into the battery can (5) from the center hole of the rivet means (76) of the negative electrode terminal assembly (7), the rubber plug (79) is inserted in the opening of the rivet means (76), and then the negative electrode terminal (8) is welded on the rivet means (76) to seal the battery can (5) as shown in Fig. 1.

[0027]

When lithium ion secondary batteries A and B of the present invention are connected in series, the aluminum layer (82) of the negative electrode terminal (8b) contacts the connecting plate (55a) made of aluminum of battery A to prevent electric corrosion caused by contact of different metals because the lithium ion

secondary battery of the present invention includes the negative electrode terminal (8) which has the clad structure consisting of the nickel layer (81) and aluminum layer (82).

Even if a battery does not include the connecting plate (55), the negative electrode terminal (8b) of the battery B contacts the lid (53a) made of aluminum or the terminal connector part (9) made of aluminum. Therefore, electrical corrosion caused by the contacting of different metals does not occur.

[0028]

As shown in Fig. 12, even if the battery has the connecting assistant plate (55) comprising a clad structure of an aluminum layer (56) and a nickel layer (57) instead of the negative electrode terminal (8) comprising the clad structure of a nickel layer (81) and an aluminum layer (82), the same metals contact each other and electrical corrosion caused by contact of different metals does not occur.

[0029]

The lithium ion secondary battery of the present invention has a structure that the spirally wound electrode unit (4) connects the negative electrode terminal assembly (7), and the connecting pieces (63) secured on the negative electrode current collector plate (6) are connected directly to the flange (70) of the terminal connector

(71) of the negative electrode terminal assembly (7) without a tab which is conventionally used to improve productivity and to reduce the length of the current path between the spirally wound electrode unit (4) and the negative electrode terminal (8), to reduce deadspace inside the battery can (5) and to reduce internal resistance.

[0030]

The lithium ion secondary battery of the present invention has a structure that, to connect the spirally wound electrode unit (4) to the lid (53) of the can (5), which is the positive electrode terminal portion, the terminal connector part (9) secured to the current collector plate (61) on the positive electrode side is inserted into the central hole (58) formed on the lid (53) to connect the terminal connector part (9) directly to the lid (53) without a tab which is conventionally used after a negative electrode terminal assembly (7) is connected to a spirally wound electrode unit (4). This structure makes it possible to apply laser beam welding from outside of the can to improve productivity and to reduce the length of the current path between the spirally wound electrode unit (4) and the lid (53), to reduce internal resistance and the number of parts.

[0031]

It is of course understood that the present invention is not limited to the embodiments explained above and can be modified within the spirit and scope of the appended claims. For example, polarity of the negative and positive electrodes can be reversed, the spirally wound electrode unit (4) can be housed upside down in the battery can (5) and the negative electrode terminal (8) is changed to the positive electrode terminal and the negative electrode terminal is formed by the battery can (5).

[BRIEF DESCRIPTION OF DRAWINGS]

[Fig. 1]

It is a cross sectional view of a lithium ion secondary battery of the present invention.

[Fig. 2]

It is a perspective view, partly in development, of a spirally wound electrode unit.

[Fig. 3]

It is an exploded perspective view of a negative electrode terminal assembly.

[Fig. 4]

It is a perspective view of a negative electrode current collector plate having connecting pieces.

[Fig. 5]

It is a perspective view of a negative electrode current

collector plate having connecting pieces of a different shape.

[Fig. 6]

It is a partial view showing the step of connecting the negative electrode current collector plate to the negative electrode terminal assembly.

[Fig. 7]

It is a partial view of a portion of the negative electrode current collector plate connected to the negative electrode terminal assembly.

[Fig. 8]

It is a perspective view showing a base lid welded to a terminal connector part.

[Fig. 9]

They are perspective views showing a positive electrode current collector plate and a positive electrode current collector plate having the terminal connector part connected thereto, respectively.

[Fig. 10]

It is a partial view illustrating the step of connecting the terminal connector part to a battery can.

[Fig. 11]

It is a partial view of batteries of the invention connected in series.

[Fig. 12]

It is a partial view illustrating the construction of a connecting plate having a clad structure secured on the lid of a battery can.

[Fig. 13]

It is a cross sectional view of a conventional lithium ion secondary battery.

[Fig. 14]

It is a cross sectional view of conventional batteries connected in series.

[Explanation of elements]

5: battery can

51: cylinder

52: upper lid

53: base lid

4: spirally wound electrode unit

6: current collector plate

61: current collector plate

62: arc-shaped protrusion

63: connecting piece

64: connecting piece

7: negative electrode terminal assembly

71: terminal connector

70: flange portion

72: first insulator
73: second insulator
76: rivet means
8: negative electrode terminal
81: nickel layer
82: aluminum layer
9: terminal connector part
90: weld



Fig. 1

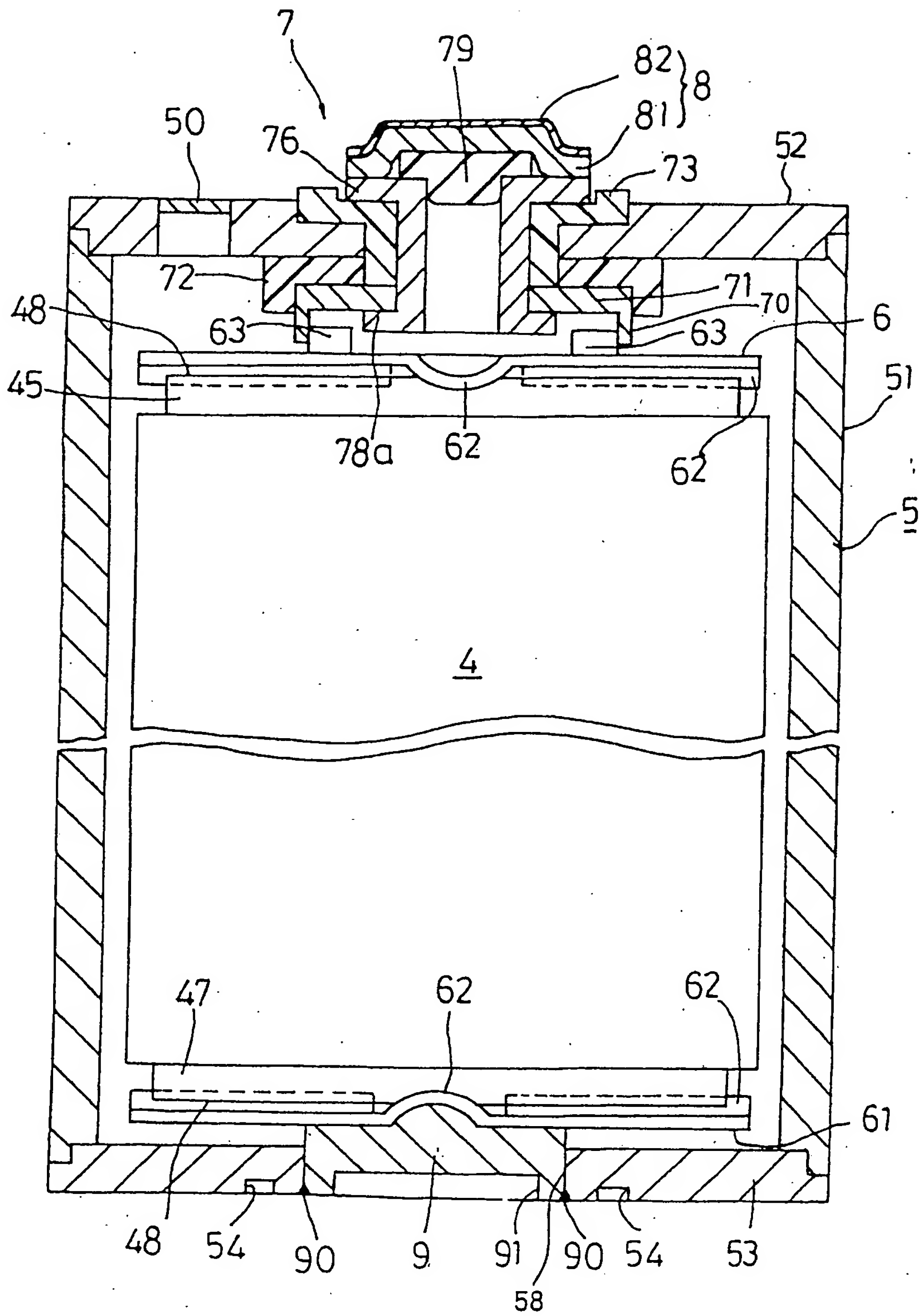


Fig. 2

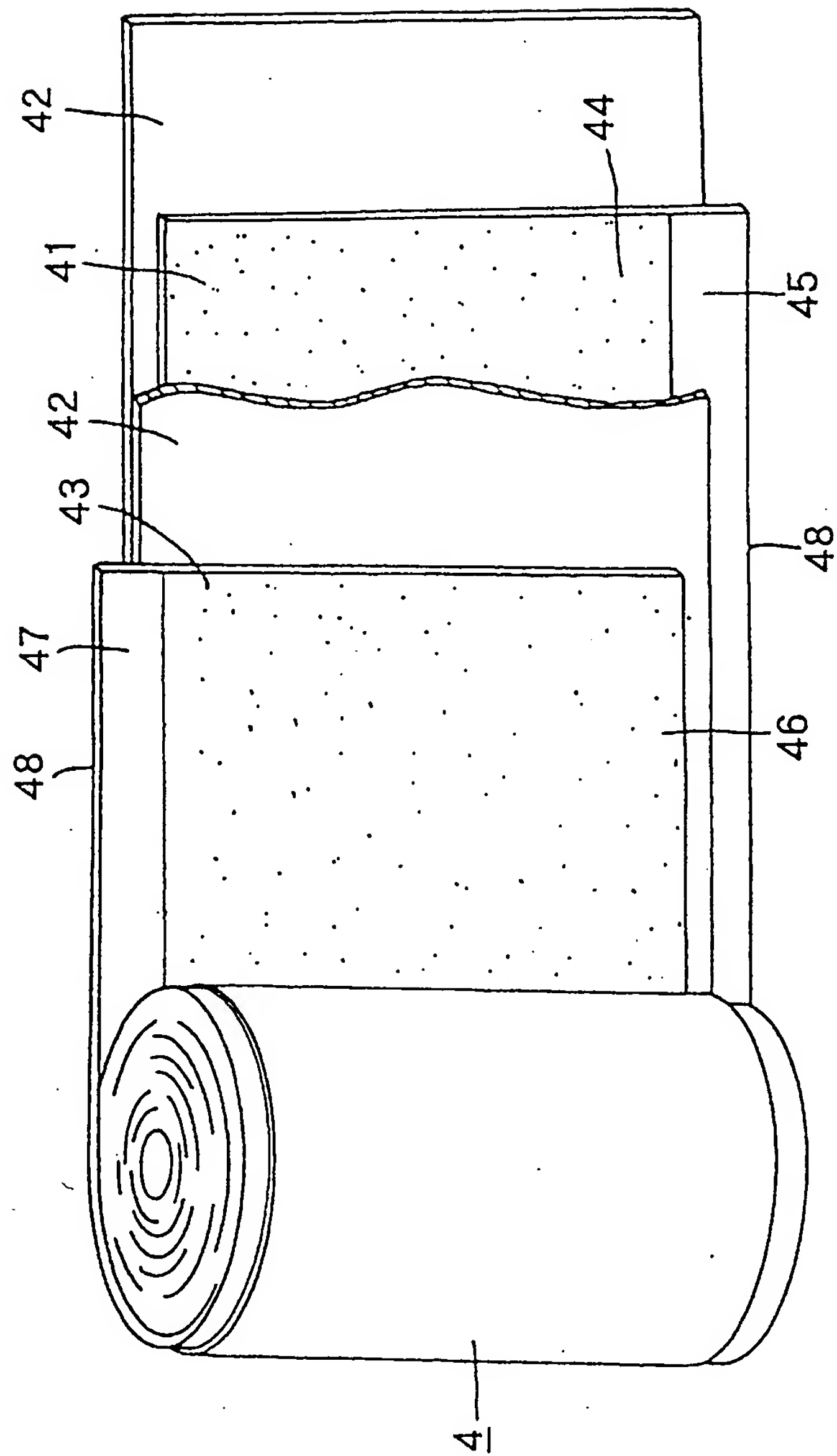


Fig. 3

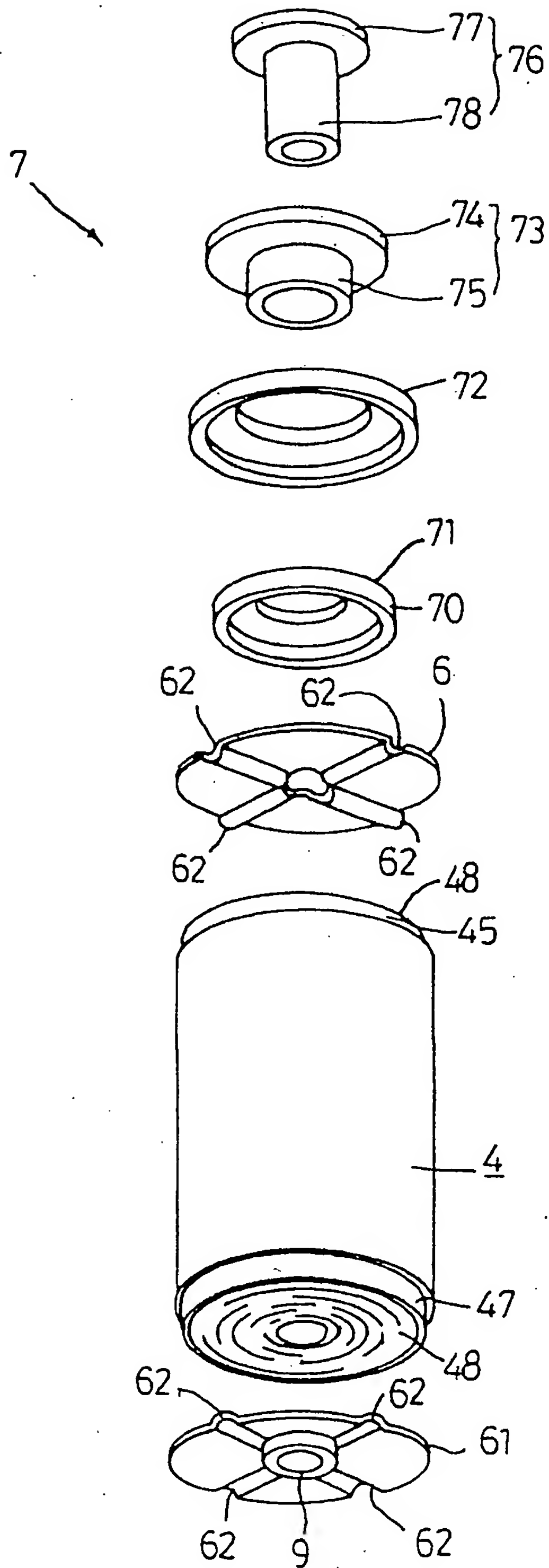


Fig. 4

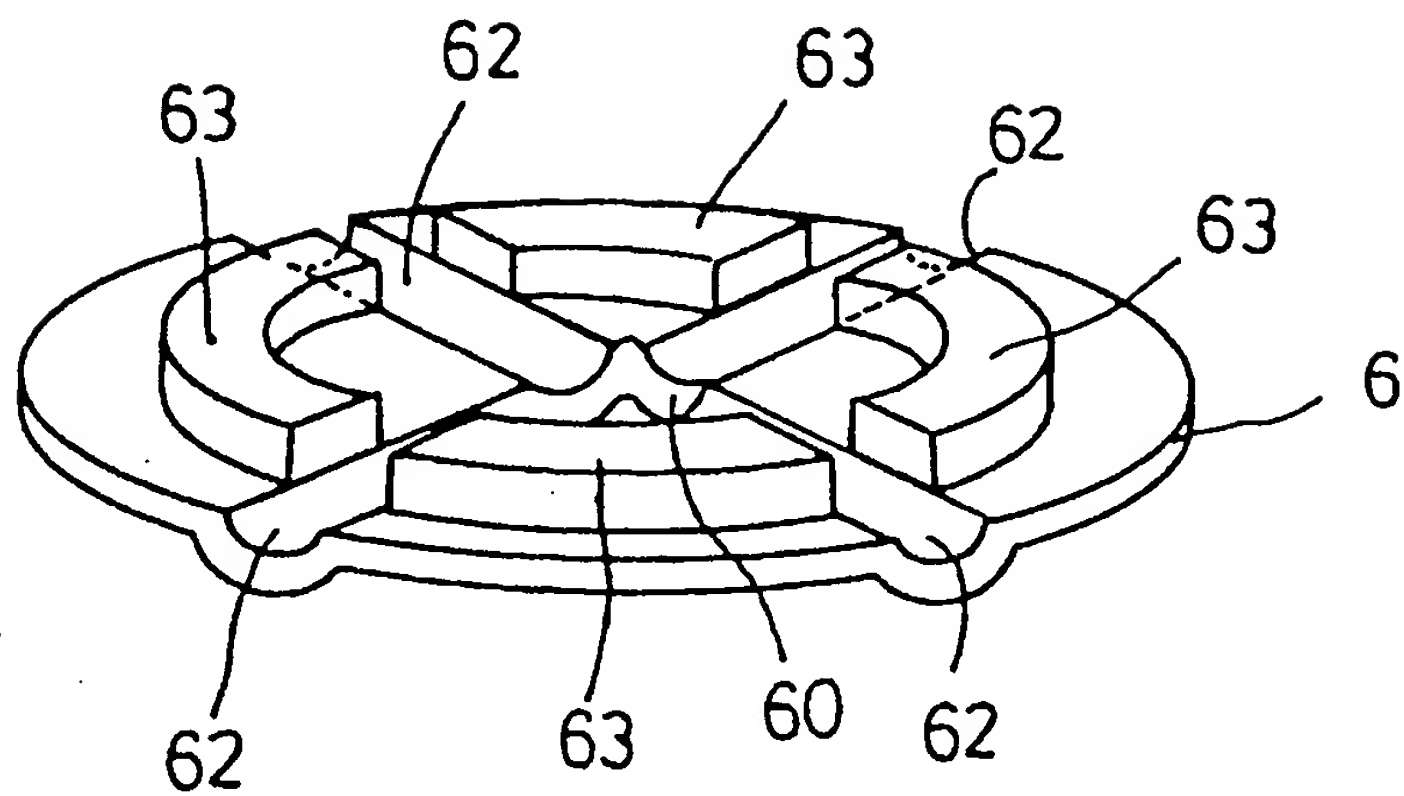


Fig. 5

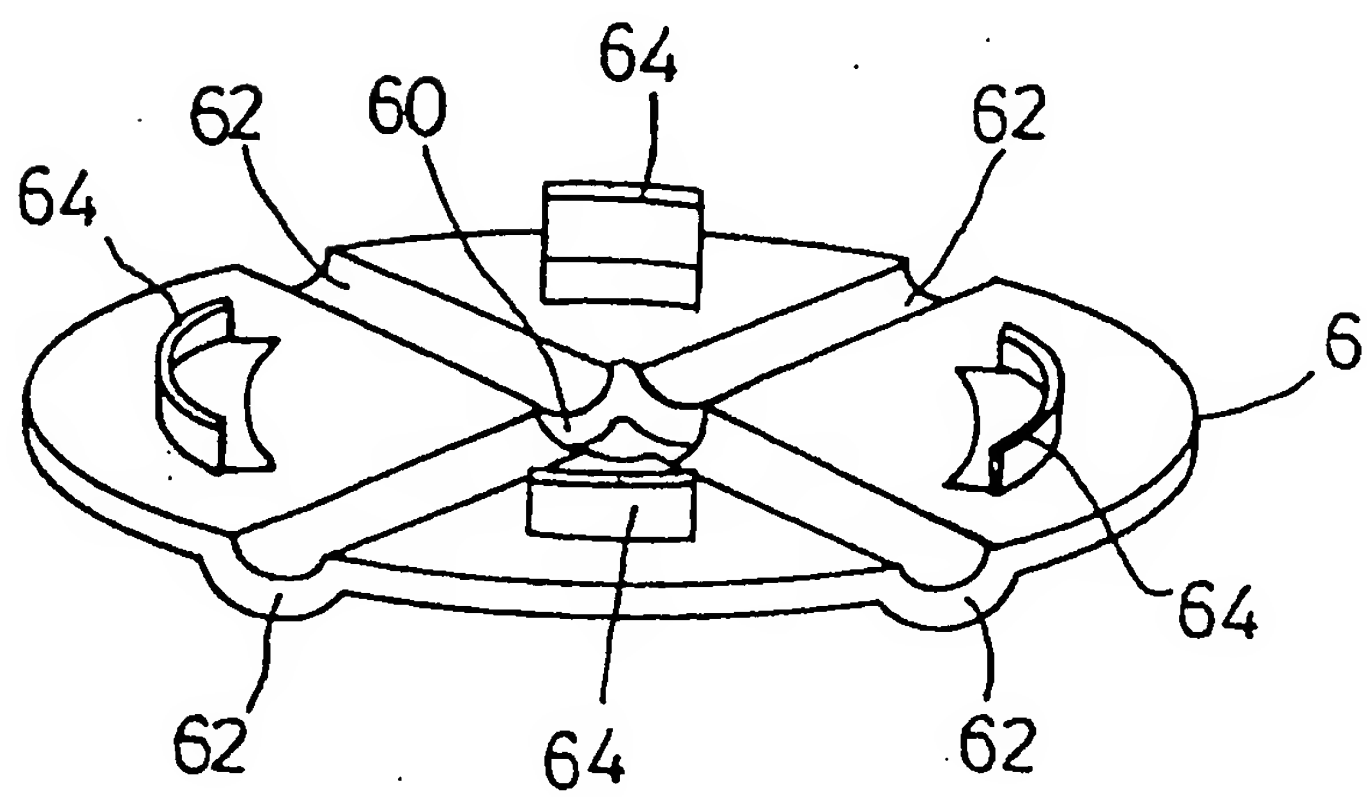


Fig. 6

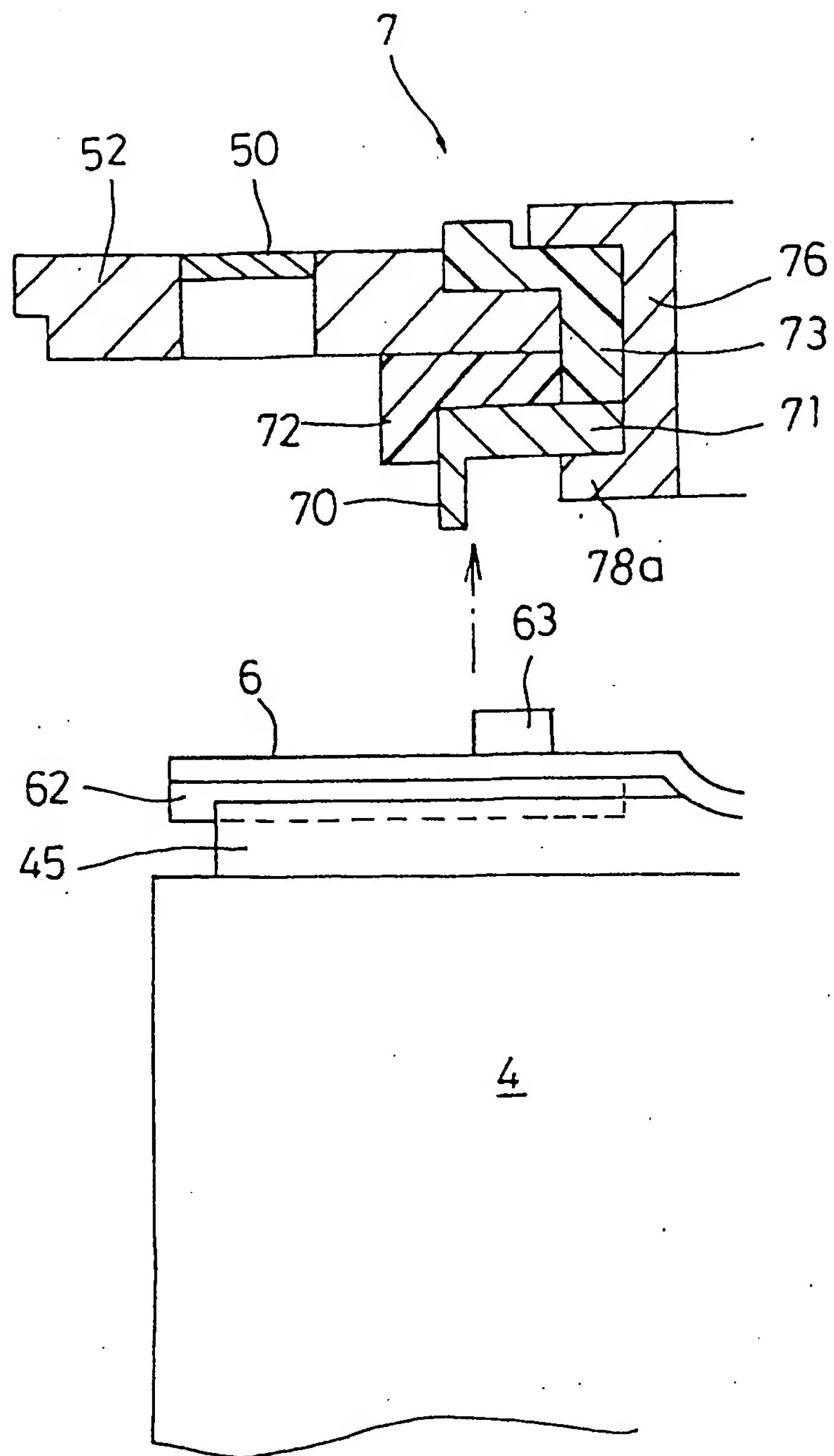


Fig. 7

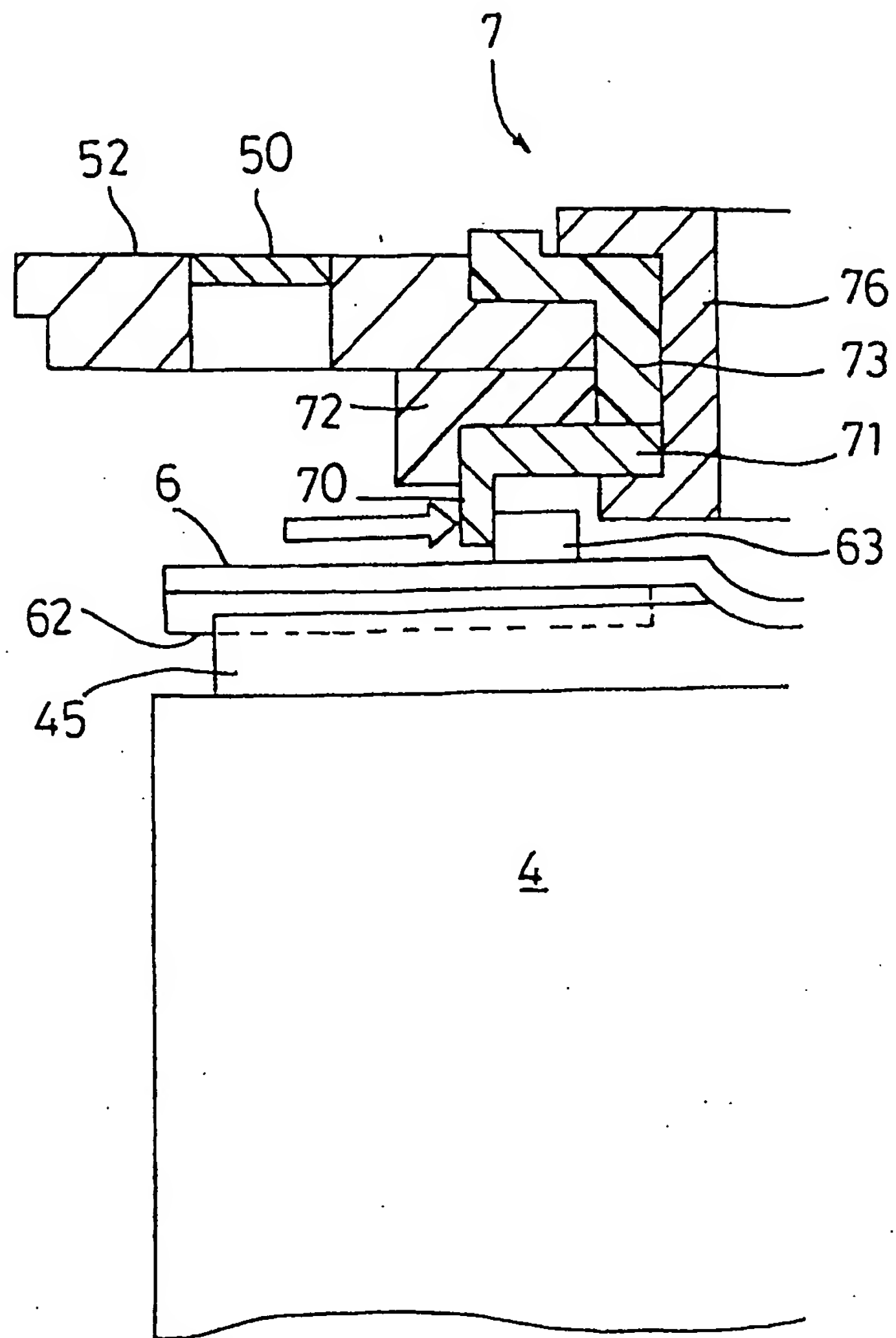


Fig. 8

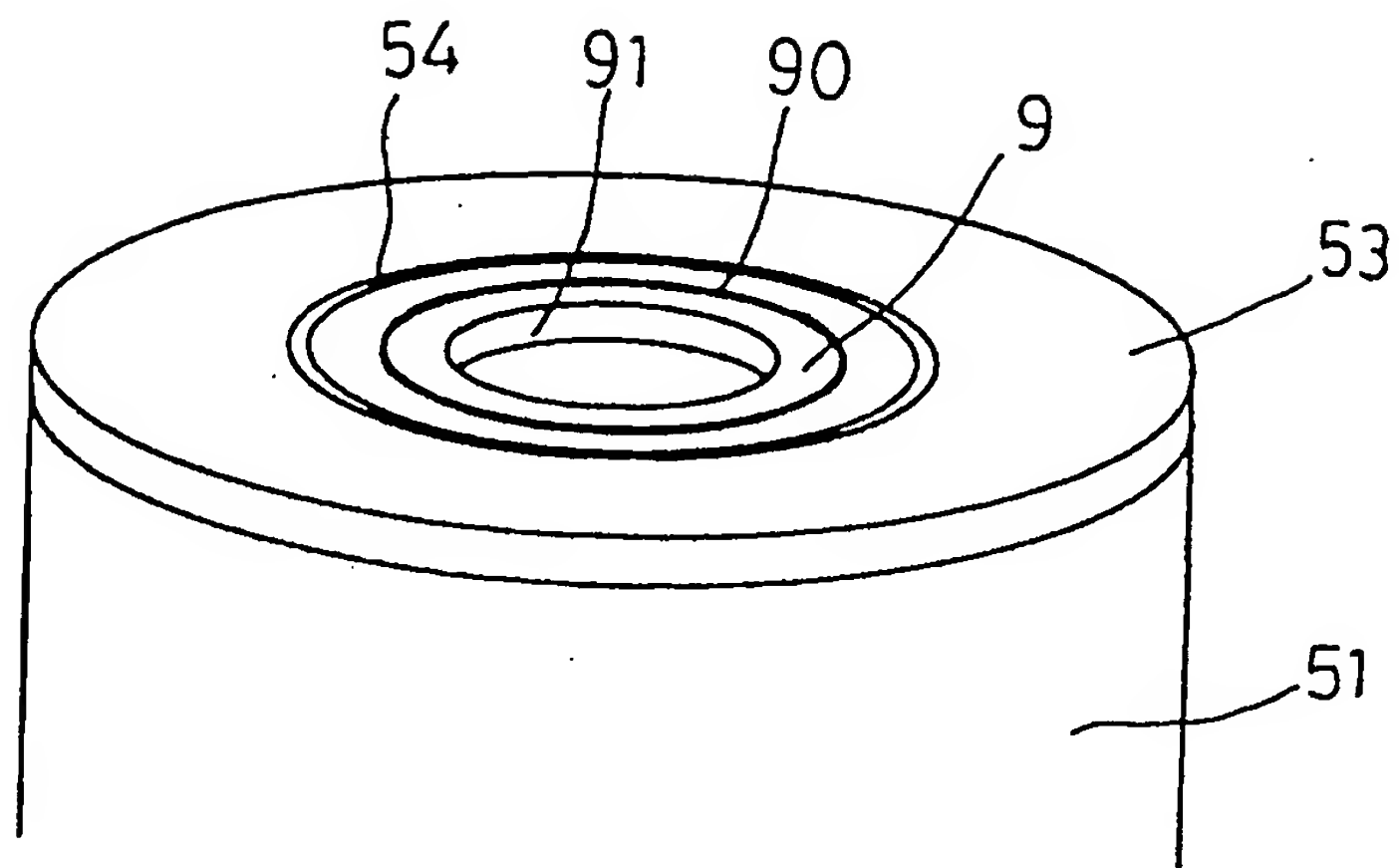


Fig. 9(a)

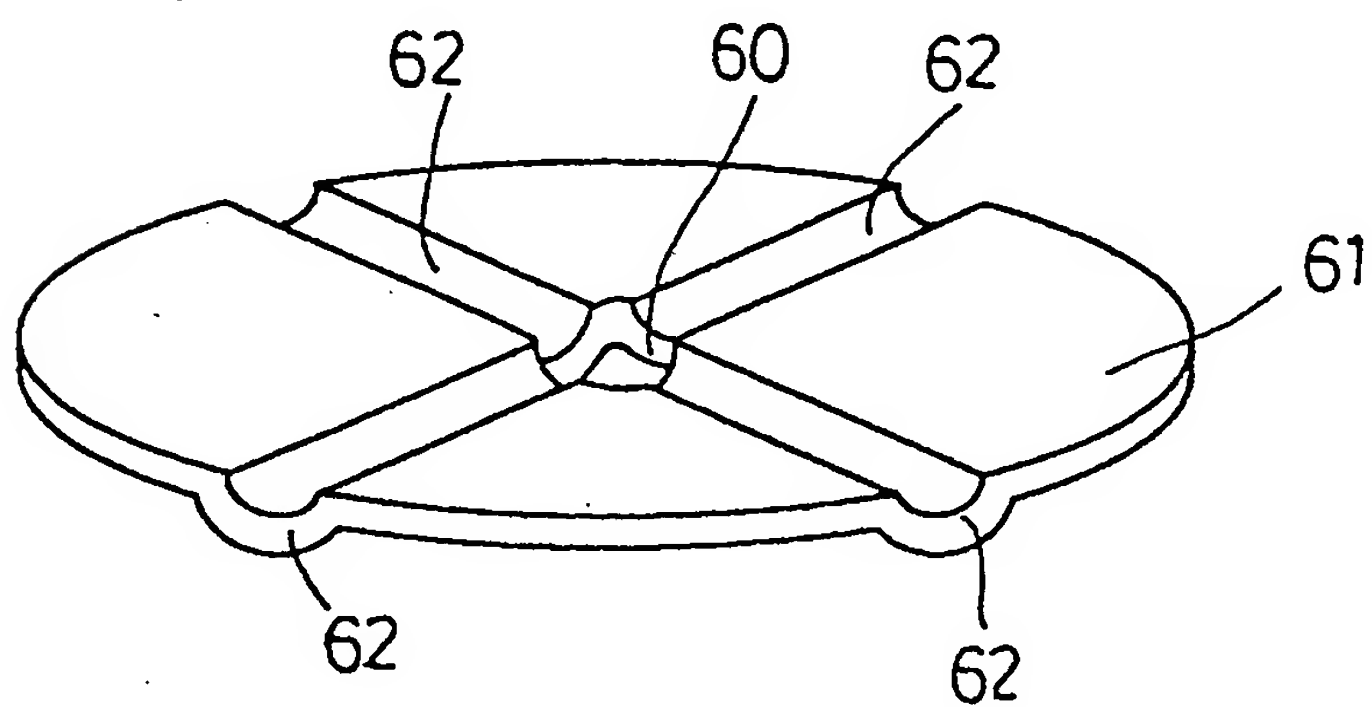


Fig. 9(b)

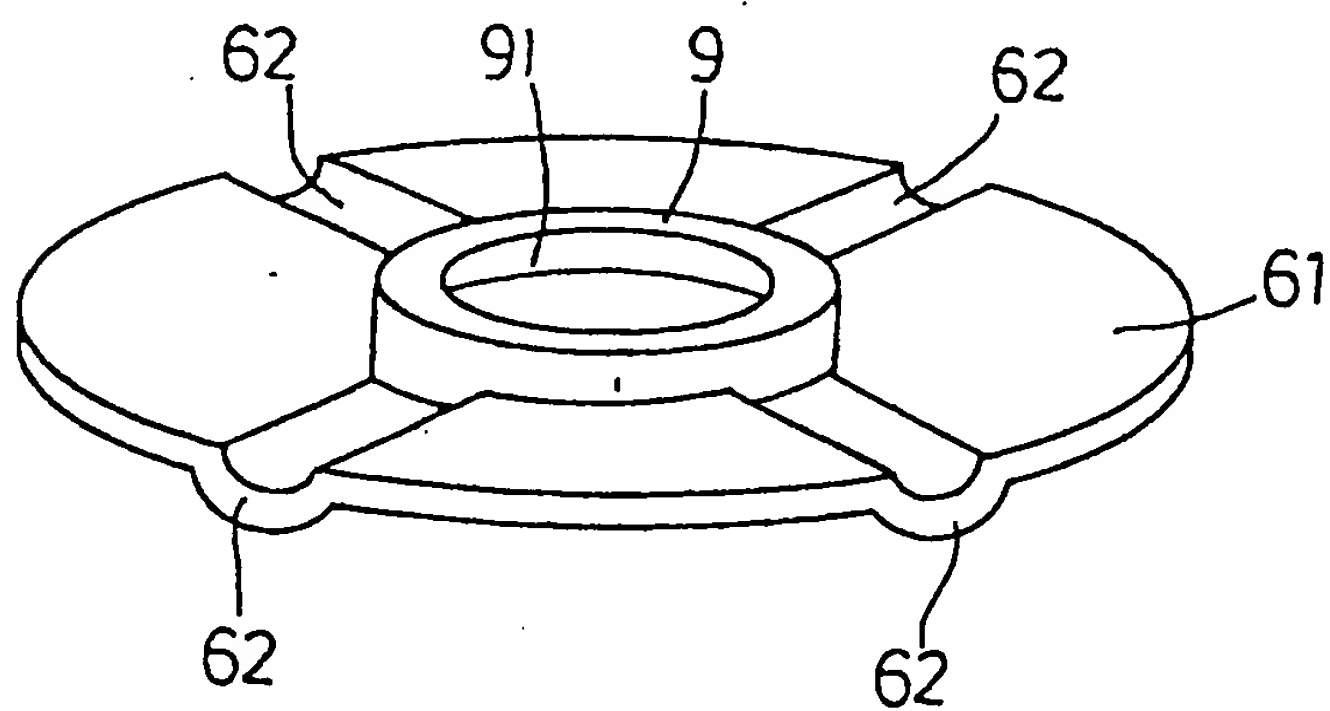


Fig. 10

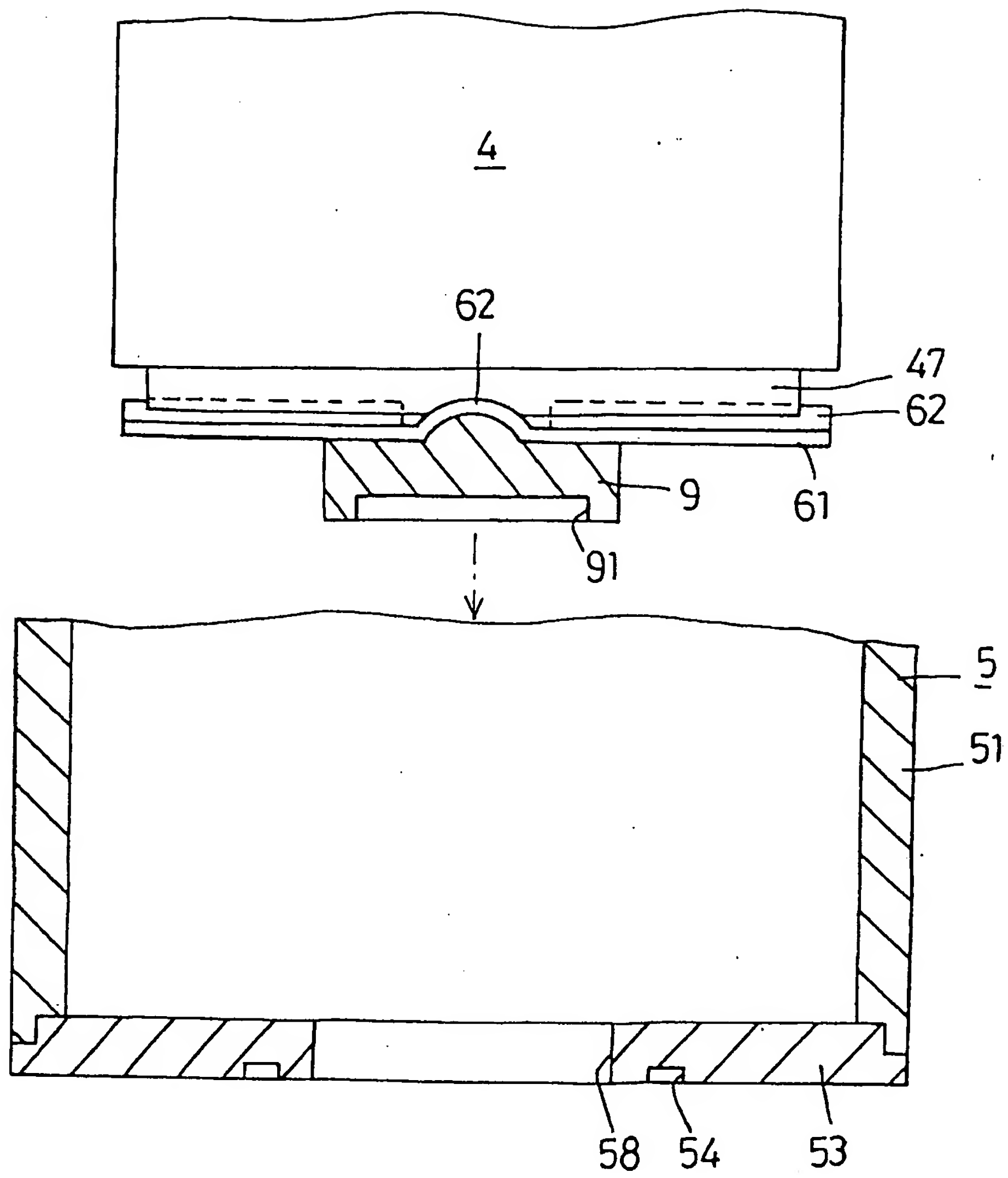


Fig. 11

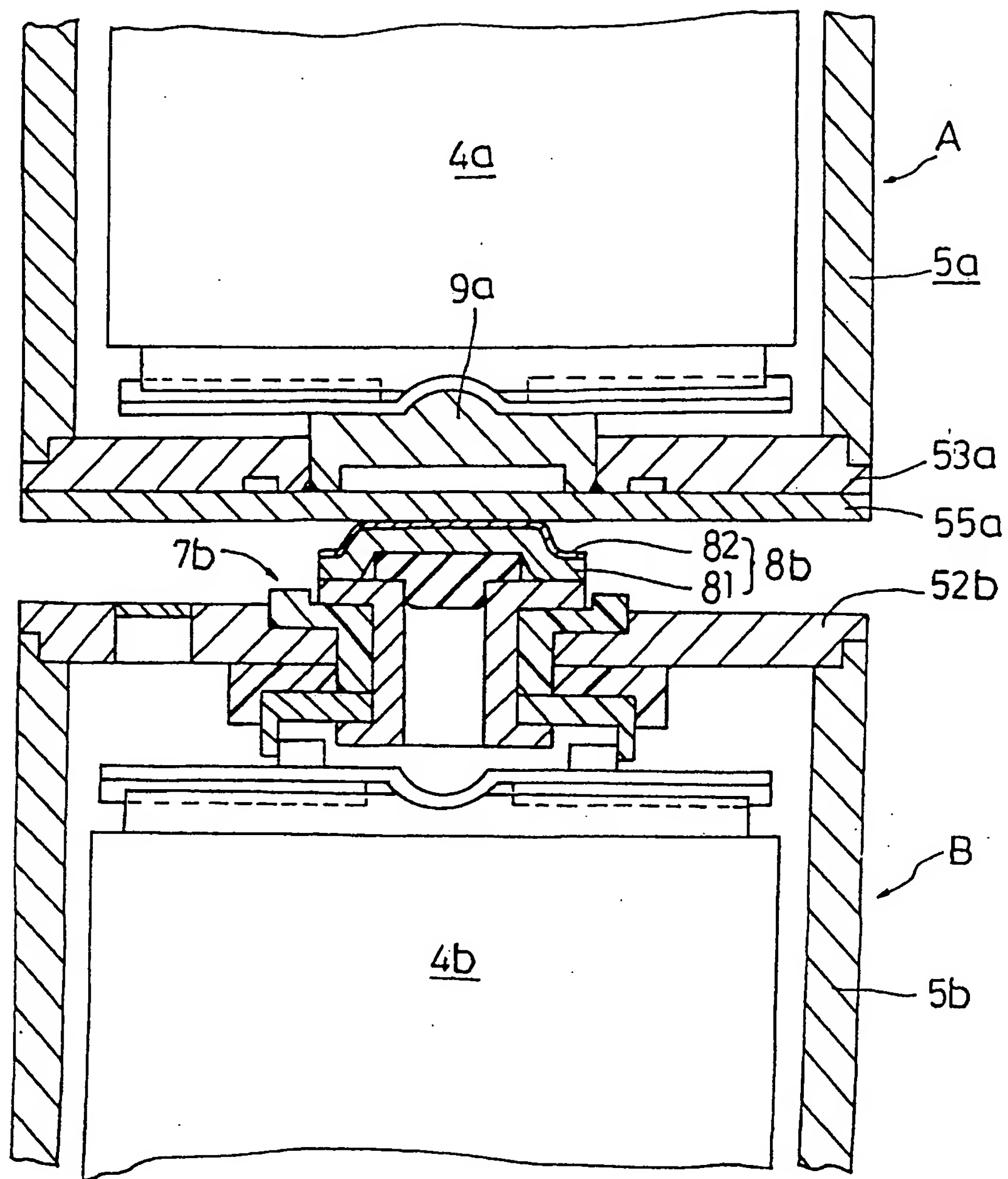


Fig. 12

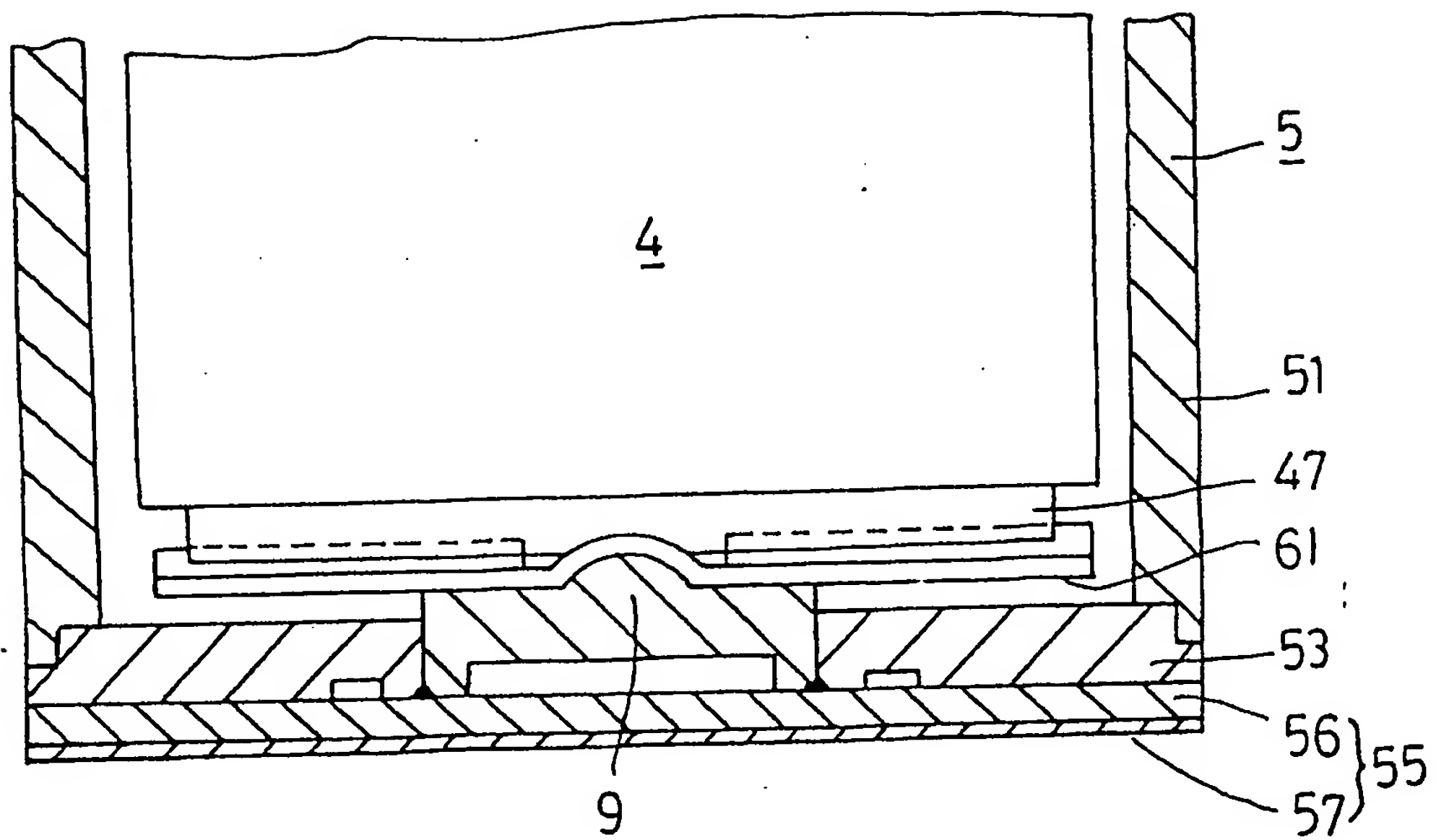


Fig. 13

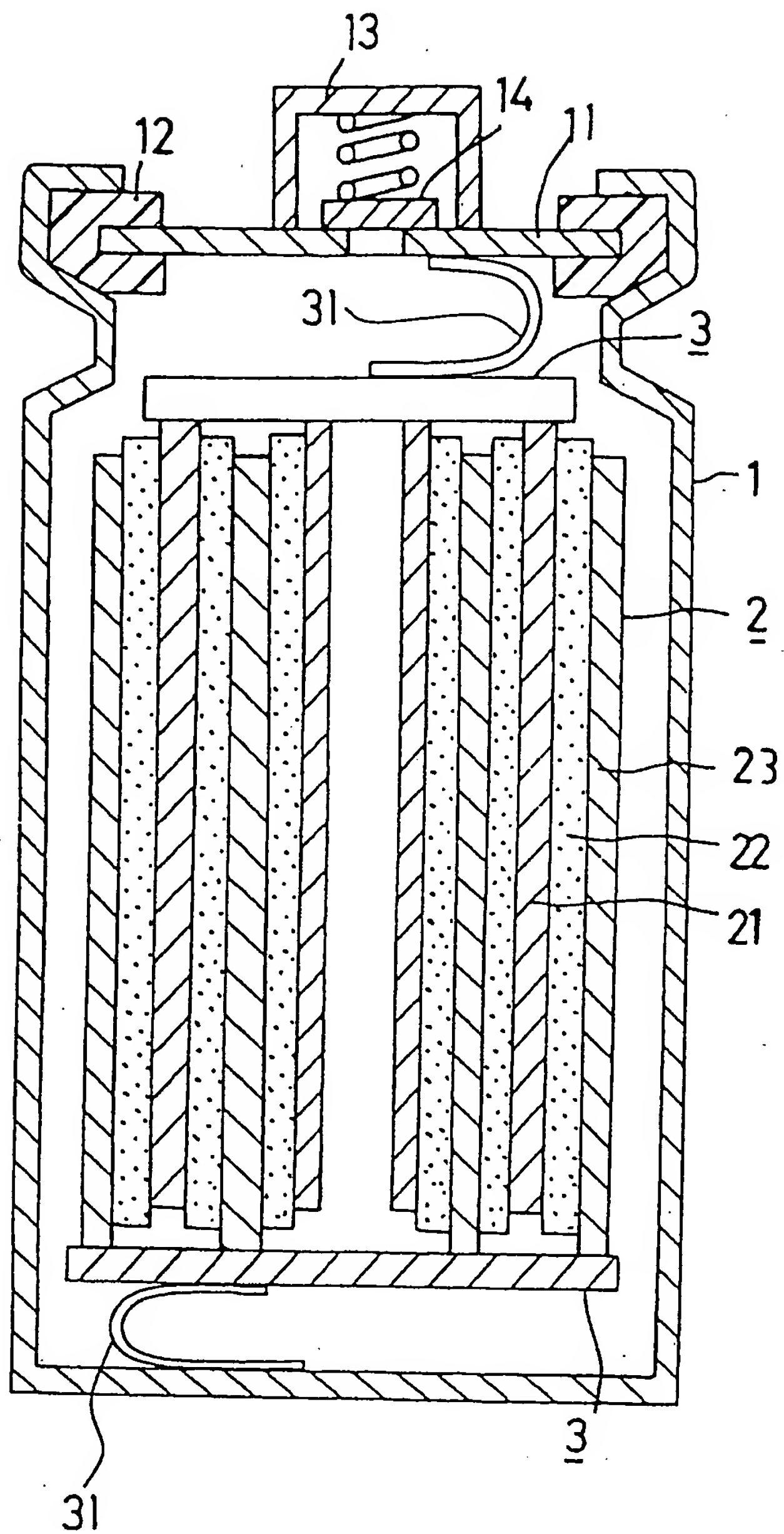
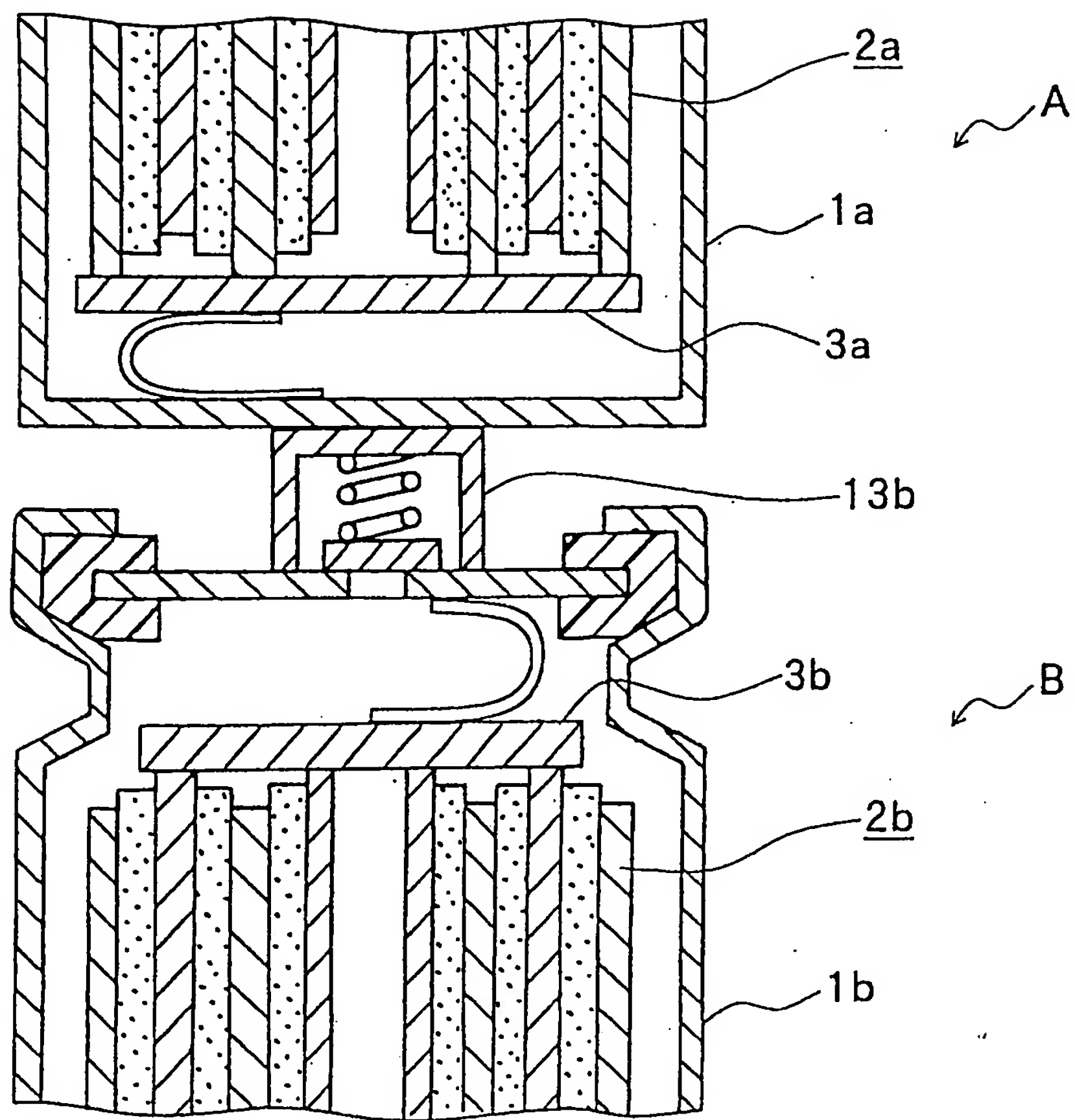


Fig. 14



[DOCUMENT NAME] SUMMARY PAPER

[SUMMARY]

[OBJECTS] A battery includes a wound electrode unit housed in a battery can and which generates electricity which can be taken out of the battery via a pair of negative and positive electrode terminals, in which the internal resistance is reduced and battery volume efficiency is increased.

[MEANS FOR SOLVING THE PROBLEM] A battery can 5 contains terminal assembly 7 which is one of the electrode terminals, a current collector plate 6 connected to an end of a wound electrode unit 4 which connects to the terminal assembly 7, plural connection pieces 63 formed on the surface of the current collector plate 6, flange portion 70 to be connected to the outer circumference of the plural connection pieces 63 formed at a bottom of a negative electrode terminal assembly 7, and flange portion 70 welded by laser to the plural connection pieces 63.

[SELECTED FIGURE] Fig. 1